












Date: Thursday, 3/23/2006 3:14:37 PM
User: COSS systems

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services		Drawing Name : LUG WELDMENT	
Job Number : 26359			
Estimate Number : 12116			
P.O. Number : N/A		Part Number : D335313	
This Issue : 3/23/2006 S.O. No. : N/A		Drawing Number : D3353 REV. A	
Prsht Rev. : NC		Project Number : N/A	
First Issue : 3/23/2006 Type : LARGE FAB ASSY		Drawing Revision : A	
Previous Run :		Material : N/A	
Written By : <u>See Comment Below</u>		Due Date : 3/30/2006 Qty: 8 Um: Each	
Checked & Approved By : <u>[Signature]</u>			
Comment : est rev A 06.01.26 new issue EC			
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M1018TR1250W109	1010-1025 Steel Tubing	
			
Comment: Qty.: 0.9188 f(s)/Unit Total : 7.3500 f(s) AISI 1018-1025 mild steel seamless round tubing 1.250" od X 0.109" wall batch: <u>M15925</u> <u>16949</u> <u>M1018IR</u>			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut blank 10.50" long as per dwg D3353 <u>[Signature]</u> 06.03.23 8			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
			
Comment: CONVENTIONAL MILLING MACHINE 1- Drill & tap as per dwg D3353 <u>[Signature]</u> 06.03.24 8 2-Deburr as per dwg D3353 <u>[Signature]</u> 06.03.24 8			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP <u>EP</u> 06/03/24 8			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST428</u> <u>C206/03/27</u> <u>[Signature]</u>			

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Process Sheet

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Drawing Name: LUG WELDMENT

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SD 06/03/08 (9)

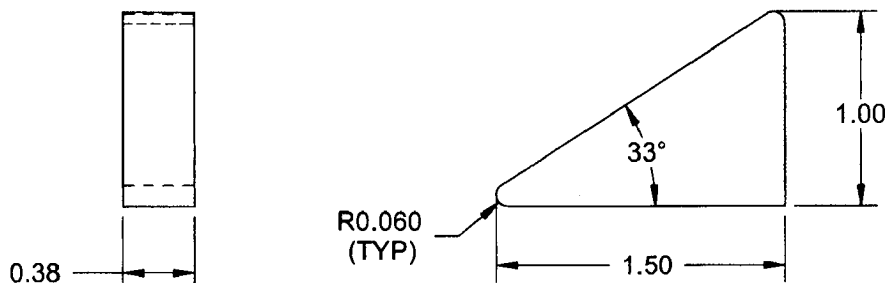
Job Completion



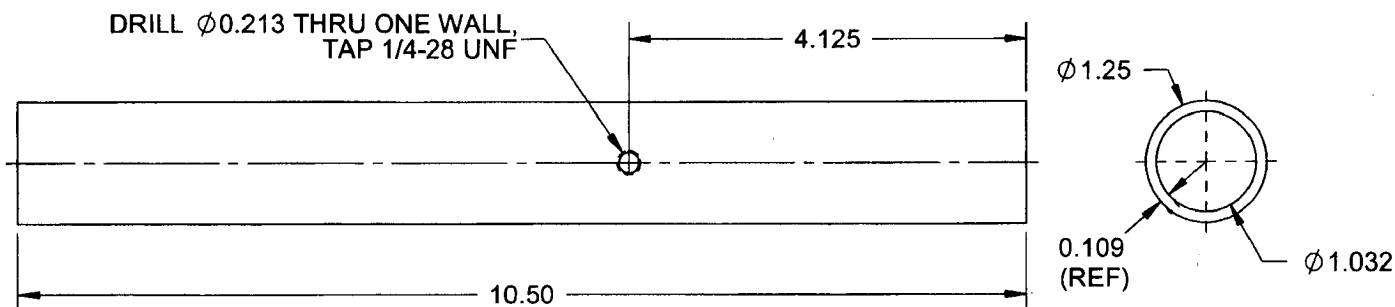
u 06.03-28

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3353	REV. A SHEET 7 OF 10
DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

RELEASED
3/33/09**D3353-9 STOP PLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK
MILD STEEL BAR (REF. DART SPEC. M1010-B)

**D3353-13 TUBING****NOTES:**

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,
Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING
(REF. DART SPEC. M1020TR1.250W.109)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26359
Description: Lug weldment		Part Number:	D3353-13
Inspection Dwg:	D3353	Rev:	A
			Page 1 of 1


Part Number: D3353-13

Inspection Dwg: D3353 Rev: 1A

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☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.50	± 0.030	10.503	✓			
4.125	± 0.010	4.124	✓			
$\phi 0.213$	± 0.005 -0.001	0.213	✓			
1/4-28UNF	N/A	1/4-28UNF	—			check with tap.
$\phi 1.25$	± 0.030	1.25	✓			mat.
0.109	± 0.010	0.109	✓			mat.
$\phi 1.032$	± 0.010	1.030	✓			mat.

Measured by: 
Date: 06/03/24

Audited by: En
Date: 06/03/24

Prototype Approval: **N/A**
Date: **N/A**

Rev	Date	Change
A		New Issue

Revised by	Approved
KJ:RE	